Monday, 11/19/2007 4:01:50 PM

Dart Aerospace Ltd.

Process Sheet

: CU-DAR001 Dart Helicopters Services Customer

EC

EC

EC

: PILOT/CO-PILOT STEP, RH (FOLDING) Drawing Name

Job Number : 35820

Estimate Number : 10824

P.O. Number

User

: 11/19/2007 S.O. No. : This Issue

Kim Johnston

: NC Prsht Rev. : 11 First Issue

: 34836 Previous Run

Written By Checked & Approved By

Comment

: EST. REV. A 05.11.21

NEW ISSUE EST. REV. B 05.12.19 updated pick list EST. REV.C 07.11.12 ecn 1019, nochg

: LARGE FAB ASSY

verifiedby:DD

Type

: D412630032 Part Number · IIN D412-630

Drawing Number Project Number : N/A : L **Drawing Revision**

Material

: 12/12/2007 Due Date

Each

Additional Product

Job Number:

Seq. #: 1.0

Machine Or Operation:

Description: DOCUMENT CONTROL

Comment: DOCUMENT CONTROL

Photocopy D412-630 bluefile & type labels per PPP412-630-032 CHG001

SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per dwg D412-630 p.17

****ensure tension to retract step is 11 to 18 lbs before installing lockwire.****

08-01-2406

07.11.291

3.0

2.0

D3463042

Step Weldment



Comment: Qty.:

1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

D3463-042 1

Step weldment

4.0

D3443043

Strut Weldment Assembly

Comment: Qty.:

1.0000 Each(s)/Unit

Total:

3.0000 Each(s)

Pick: Qty

Part Number D3443-043

Description Strut ass'y

35858

08/1/220

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rospace Lt	d							
		W	ORK ORDER CHANGES	3				
STEP	PR	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
:	PAR #:	Fault Cat	egory:					
		WORK OR	DER NON-CONFORMAN	CE (NCR)			
CONTRACTOR OF STREET	Description of NC		Corrective Action Section	В	Vorifica	tion	Anneoval	Annaval
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date			Chief Eng	Approval QC Inspector
	STEP	STEP PRODUCTION OF NC	STEP PROCEDURE CH. PAR #: Fault Cat WORK ORE STEP Description of NC Section A Initial	STEP PROCEDURE CHANGE PROCEDURE CHANGE PAR #: Fault Category: WORK ORDER NON-CONFORMAN STEP Description of NC Section A Corrective Action Section Initial Action Description	WORK ORDER CHANGES STEP PROCEDURE CHANGE By PAR #: Fault Category: NCR: Yes QA: N/ WORK ORDER NON-CONFORMANCE (NCR STEP Description of NC Section A Section B Initial Action Description Sign &	STEP PROCEDURE CHANGE By Date DESCRIPTION OF NC Section A Section B Section B Section B Section B Section A Section B Section A Section B Section A Section B Section B Section A Section B Section	STEP PROCEDURE CHANGE By Date Qty DESCRIPTION OF NC Section A Section C Sec	STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr DE PAR #: Fault Category: NCR: Yes No DQA: Date: QA: N/C Closed: Date: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Section A Section B Section C Section C Section C Section C Section C Chief Eng / Prod Mgr

Date: 1 MOUNTAN, 11/19/2007 4.01.501 W Kim Johnston User: **Process Sheet** Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Part Number: D412630032 Job Number: 35820 Job Number: Description: Seq. #: Machine Or Operation: Strut Weldment Assembly D3443041 5.0 Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s) Pick: Batch Description Qty Part Number (XI) D3443-041 Strut ass'y 1 D34439 6.0 2.0000 Each(s)/Unit Total: 6.0000 Each(s) Comment: Qty.: Pick: Description Batch Part Number Qtv 330228 D3443-9 Pin AS 08/01/15 SS Bolt AN4CH3 7.0 2.0000 Each(s)/Unit Total: 6.0000 Each(s) Comment: Qty.: Pick: Part Number Description Qty BOLT AN4CH3 Lockwire A/R MS20995c41e 5 08/01/15 BOLT AN4C14 8.0 Total: 3.0000 Each(s) Comment: Qty.: 1.0000 Each(s)/Unit Pick: Qty Part Number Description M 103248 BOLT AN4C14 1 9.0 D34547 Comment: Qty.: 6.0000 Each(s) 2.0000 Each(s)/Unit Total: Pick: Part Number Description Batch Qty 35636 D3454-7 Bushing 2

Date: Monday, 11/19/2007 4.01.00 FW Kim Johnston **Process Sheet** User: . Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Part Number: D412630032 Job Number: 35820 Job Number: Description: Seq. #: Machine Or Operation: NUT 10.0 AN3104 1.0000 Each(s)/Unit Total: 3.0000 Each(s) Comment: Qty.: Pick: Description Batch Part Number Qty M65280 AN310-4 Nut 1 COTTER PIN MS24665227 11.0 1.0000 Each(s)/Unit Total: 3.0000 Each(s) Comment: Qty.: Pick: Part Number Description Batch Qty M106043 COTTER PIN MS24665-227 1 080118 Spacer 12.0 D34551 Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s) Pick: Description Batch Qty Part Number D3455-1 Spacer 2 D34651 Washer 13.0 Comment: Qty.: 1.0000 Each(s)/Unit 3.0000 Each(s) Total: Pick: Description Qty Part Number 0801-24 D3465-1 Washer 1 14.0 AN3107 Total: 3.0000 Each(s) Comment: Qty.: 1.0000 Each(s)/Unit Pick: Qty Description Part Number M103286 Nut AN310-7 1 mp 08-01-24

Monday, 11/19/2007 4.01.501 W Date: Kim Johnston **Process Sheet** User: . Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Part Number: D412630032 Job Number: 35820 Job Number: Description: Seq. #: Machine Or Operation: Cotter Pin MS24665302 15.0 1.0000 Each(s)/Unit Total: 3.0000 Each(s) Comment: Qty.: Pick: Description Batch Part Number Qty 06763 MS24665-302 COTTER PIN 1 08-01-04 INSPECT WORK TO CURRENT STEP QC5 16.0 Comment: INSPECT WORK TO CURRENT STEP ****ensure tension to retract step is 11 to 18 lbs **** Test fit on aircraft in Eng. lab. PACKAGING RESOURCE #1 PACKAGING 1 17.0 Comment: PACKAGING RESOURCE #1 Pick Packing Kit Bushing 18.0 D34541 3.0000 Each(s) Comment: Qty.: Total: 1.0000 Each(s)/Unit Pick: Description Qty Part Number Bushing D3454-1 1 Bushina D34543 19.0 6.0000 Each(s) Comment: Qty.: Total: 2,0000 Each(s)/Unit Pick: Description Part Number Qty 35171 Bushing D3454-3 20.0 D34545 6.0000 Each(s) Comment: Qty.: 2.0000 Each(s)/Unit Total: Pick: Description 1934847 Qty Part Number Bushing D3454-5 2

MONUAY, 11/19/2007 4.01.00 PM Kim Johnston User: **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING) Job Number: 35820 Part Number: D412630032 Job Number: Seq. #: Machine Or Operation: Description: 21.0 D34551 Spacer Comment: Qty.: Total: 18.0000 Each(s) 6.0000 Each(s)/Unit Pick: Qty Part Number Description Batch 6 D3455-1 Spacer 22.0 D34553 Spacer Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s) Pick: Qty Part Number Description Batch 2 D3455-3 Spacer D3462042 23.0 Comment: Qty.: 3.0000 Each(s) 1.0000 Each(s)/Unit Pick: Qty Part Number Description Batch 1 D3462-042 Bracket ass'y 24.0 AN3104 NUT Comment: Qty.: 1.0000 Each(s)/Unit 3.0000 Each(s) Total: Part Number Batch Description 1105080 AN310-4 Comment: Qty.: 2.0000 Each(s)/Unit 6.0000 Each(s) Total: Pick: Qty Part Number Description M105280 AN310-5 Nut AN3C5A Bolt Comment: Qty.: 9.0000 Each(s) 3.0000 Each(s)/Unit Total: Pick: Qty Part Number Description Batch Page 5

Monday, 11/19/2007 4:01:50 PM Date: Kim Johnston 'User: ' **Process Sheet** Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Job Number: 35820 Part Number: D412630032 Job Number: Description: Seq. #: Machine Or Operation: Bolt 3 AN3-C5A 27.0 AN44C12 eyebolt Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s) Pick: Qty Part Number Description Batch 1106297 AN44-C12 Eyebolt BOLT 28.0 AN4C15 Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s) Pick: Description Qty Part Number M103248 BOLT 1 AN4C15 SO BOLT 29.0 AN5C11 Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s) Pick: Part Number Description Qty 1103248 BOLT AN5C11 30.0 AN5C15 BOLT Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s) Pick: Qty Part Number Description M105/60 BOLT AN5C15 WASHER AN960C10 Comment: Qty.: 7.0000 EACH(s)/Unit Total: 21.0000 EACH(s) Pick: 8 08/01/11 Qty Part Number Description AN960C10 Washer

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W/O:			Wo	ORK ORDER CHANG	ES			
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date 0	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	3							
							1	
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA:	Date: _	
					QA: N	N/C Closed: _	Date: _	
NCR:		1	WORK ORD	ER NON-CONFORMA	ANCE (NC	₹)		
III-arabera area	Construction of the Constr	Description of NC		Corrective Action Section	on B	Verificati	on Approval	Approval
DATE	STEP	Section A	Initial	Action Description	Sign	Section (QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
14-47-2-2-2-7-2		Description of NC		Verification	A	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	QC Inspector
			1					

Monday, 11/19/2007 4:01:50 PM Date: Úser: Kim Johnston **Process Sheet** Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Part Number: D412630032 Job Number: 35820 Job Number: Description: Seq. #: Machine Or Operation: AN960C516 WASHER 32.0 Comment: Qty.: Total: 3.0000 Each(s) 1.0000 Each(s)/Unit Pick: Description Qty Part Number M102842 Washer 1 AN960C516 33.0 MS210433 Nut Comment: Qty.: Total: 9.0000 Each(s) Pick: Description Qty Part Number 3 MS21043-3 Nut COTTER PIN 34.0 MS24665227 Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s) Pick: Description Part Number Qty 1106043 2 MS24665-227 COTTER PIN 35.0 MS24665229 COTTER PIN 2.0000 Each(s)/Unit 6.0000 Each(s) Comment: Qty.: Total: Pick: Description Qty Part Number COTTER PIN 2 MS24665-229 36.0 NAS1515H5 Washer Comment: Qty.: Total: 3.0000 Each(s) 1.0000 Each(s)/Unit Pick: Description Batch Qty Part Number M 100203 NAS1515H5 Washer 8/1/24 50

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W/O:			WC	RK ORDER CHANGES					
DATE	STEP	PRO	CEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	gory:N	CR: Yes	No DQ	A:	Date:	
								_ Date: _	
NCR:		V	VORK ORDE	ER NON-CONFORMANO	CE (NCF	2)			
and processes		Description of NC		Corrective Action Section B		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti		Chief Eng	QC Inspector

Monday, 11/19/2007 4:01:50 PM Date: Kim Johnston User: **Process Sheet** Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Job Number: 35820 Part Number: D412630032 Job Number: Description: Seq. #: Machine Or Operation: INSPECT 100% KITS FOR COMPLETENESS QC4 37.0 Comment: INSPECT 100% KITS FOR COMPLETENESS PACKAGING RESOURCE #1 PACKAGING 1 38.0 Comment: PACKAGING RESOURCE #1 Identify and pack for shipping as per PPP D412-630-031 Location: PPP Rev: FINAL INSPECTION/W/O RELEASE 39.0 QC21 TION/W/O RELEASE U 08-01-25 Job Completion I chocked put parts that were sent out ordulity ordulity

Dart Ae	rospace	e Ltd							
W/O:			W	ORK ORDER CHANGES					
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cat	egory: NC				_ Date: _	
NCR:			WORK ORE	DER NON-CONFORMANC	E (NCR)			
50 (8-55	2500000	Description of NC		Corrective Action Section B		Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		on C	Chief Eng	QC Inspector

D412-630-031/-032 Pilot/Co-Pilot Folding-Step Installation

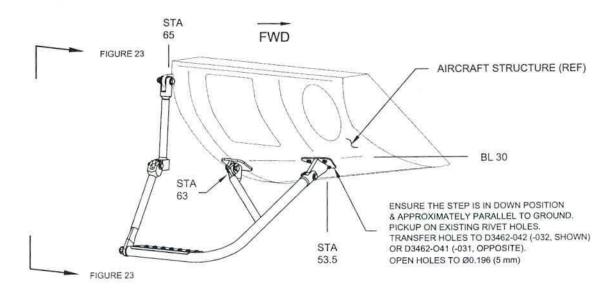


FIGURE 21 - Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown), D412-630-031 LH (Opposite)

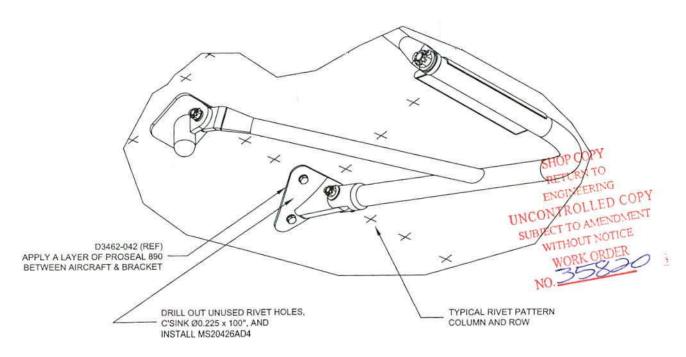


FIGURE 22 - Detail View D3462-042 Bracket Assembly (-032 Installation, Shown) D3462-041, (-031 Installation Opposite)

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07.09.30

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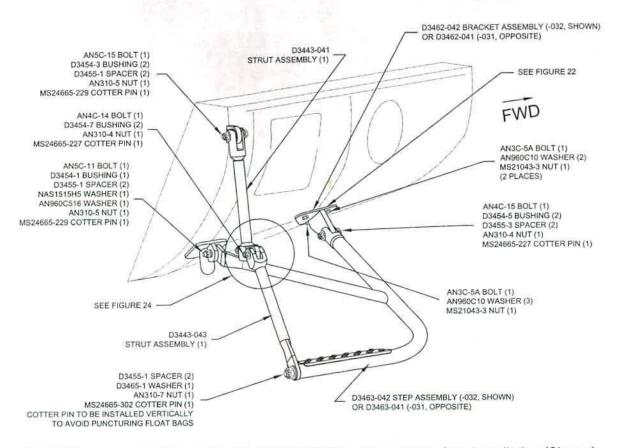


FIGURE 23 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown) D412-630-031 LH (Opposite)

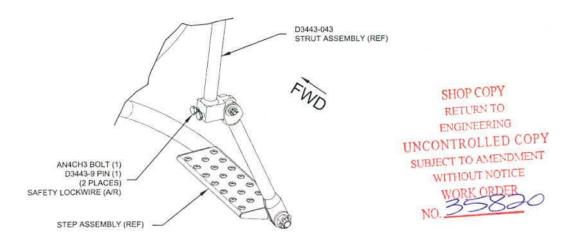


FIGURE 24 - Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown) D412-630-031 LH (Opposite)

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Revision:

Date:

07.09.30

Qty -031	Qty -032	Part Number	Description
Х		D412-630-031	PILOTICO-PILOT STEP, LH (FOLDING)
	Х	D412-630-032	PILOTICO-PILOT STEP, RH (FOLDING)
1	1	D3443-041	STRUT ASSEMBLY
1	1	D3443-043	STRUT ASSEMBLY
2	2	D3443-9	PIN
1	1	D3454-1	BUSHING
2	2	D3454-3	BUSHING
2	2	D3454-5	BUSHING
2	2	D3454-7	BUSHING
6	6	D3455-1	SPACER
2	2	D3455-3	SPACER
1		D3462-041	BRACKET ASSEMBLY
	1	D3462-042	BRACKET ASSEMBLY
1		D3463-041	STEP ASSEMBLY
	1	D3463-042	STEP ASSEMBLY
1	1	D3465-1	WASHER
2	2	AN310-4	NUT
2	2	AN310-5	NUT
1	1	AN310-7	NUT
3	3	AN3C-5A	BOLT
1	1	AN44-C12	* EYEBOLT
1	1	AN4C14	BOLT
1	1	AN4C15	BOLT
2	2	AN4CH3	BOLT
1	1	AN5C11	BOLT
1	1	AN5C15	BOLT
7	7	AN960C10	WASHER
1	1	AN960C516	WASHER
3	3	MS21043-3	NUT
2	2	MS24665-227	COTTER PIN
2	2	MS24665-229	COTTER PIN
1	1	MS24665-302	COTTER PIN
1	1	NAS1515H5	WASHER

^{*} USE AN44-C12 EYEBOLT WHEN D412-630-031/-032 IS INSTALLED IN CONJUNCTION WITH D412-630-023/-024™ HELI-ACCESS-STEP



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